

Work Order ID 124726

Monday, September 22, 2014 3:06:05 PM 647.3801

124726

Page 1

Item ID:	647.3801	B 1 2 4 7 2 6	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:		N / C					
Item Name:	412 Upper Cutter Assy					Stop	*NS2*
Start Date:	9/22/2014	Start Qty: 2.00	*2*	Cust Item ID:			
Required Date:	9/22/2014	Req'd Qty: 2.00	*2*	Customer:			
Reference:							

Approvals: Process Plan: MLS Date: 14-07-22 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
 Stop *NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 124726***124726***

Page 2

Monday, September 22, 2014 3:06:05 PM

Item ID: 647.3801 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 412 Upper Cutter Assy
Start Date: 9/22/2014 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 9/22/2014 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>CCK28</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

MLJ 14-09-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
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Training									
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Picklist Print

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Page 1

Work Order ID: 124726

124726

Parent Item: 647.3801

647 3801

Parent Item Name: 412 Upper Cutter Assy

Start Date: 9/22/2014

Required Date: 9/22/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.10.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701 *646 9701* Cutter Sub Assembly		Manufactured	No			110	Each	23.0000	1	2		DAS 41 9-89 14-9-22	

Location	Loc Qty	Loc Code
cck54	23	
104377	10	
110325	4	
121153	1	
121154	3	
91788	5	

NAS1149FN832P

Purchased

No

110

Each

8,280.000

6

12

DAS
41
9-89

14-9-22

NAS1149FN832P

Washer

Location	Loc Qty	Loc Code
ST275	5775	
123185	30	
123522	400	
123900	2	
125268	5343	
ST294	2505	
M130388	2505	

DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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Picklist Print

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Page 2

Work Order ID: 124726

124726

Parent Item: 647.3801

647 3801

Parent Item Name: 412 Upper Cutter Assy

Start Date: 9/22/2014

Required Date: 9/22/2014

Start Qty: 2.00

Required Qty: 2.00

MS21042L08

Purchased

No

110

Each

3,365.000

3

6

MS21042I 08

Nut

DAS

41

9-89 14-9-22

Location

Loc Qty

Loc Code

ST306

3365

123900

1

125445

268

m127304

99

m127410

628

m128401

1500

m128429

69

m129541

200

m130325

600

MS27039-08-19

Purchased

No

110

Each

1,155.000

3

6

MS27039-08-19

Screw

DAS

41

9-89 14-9-22

Location

Loc Qty

Loc Code

ST286

500

m130325

500

ST506

655

124309

25

125654

78

m127904

552

647.3910

Manufactured

No

110

Each

11.0000

1

2

647 3910

412 Upper Deflector

DAS

41

9-89 14-9-22

Location

Loc Qty

Loc Code

cck12

5

m129702

5

MF3

6

121963

6

Monday, September 22, 2014 3:06:09 PM

Shop Packet Print

Page 2

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FAULT CATEGORY

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					1	9	647.3911	212 UPPER DEFLECTOR		
					1	8	647.3910	412 UPPER DEFLECTOR		
	A/R	A/R	A/R	A/R	7		601.2045	RTV, LOCITE 598		
	I				6		647.3902	LOWER DEFLECTOR ASSY HIGH		
		I			5		647.3901	LOWER DEFLECTOR ASSY LOW		
	3	3	3	3	4		601.2765	SCREW	M527039-0819	
	3	3	3	3	3		601.1541	LOCKNUT	M521042Z08	
	6	6	6	6	2		601.2764	WASHER	FMS1149FN832P	
	I	I	I	I	I		646.9701	CUTTER SUB ASSY		
	X						647.3904	LOWER CUTTER ASSY-HIGH		
		X					647.3803	LOWER CUTTER ASSY LOW		
			X				647.3802	212 UPPER CUTTER ASSY		
				X			647.3801	412 UPPER CUTTER ASSY		
	.3804	.3803	.3802	.3801	FIND #		PART #	DESCRIPTION	MATL	SPEC.
	QTY						PARTS LIST			
	NEXT ASSY (S)						<div style="text-align: center;"> APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300 CUTTER ASSY </div>			
	647.3700									
							USE CAGE CODE	DWG NO		REV.
							R D7M/L6		647.3800	N/C
							SCALE NONE		SHEET	1 OF

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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FAULT CATEGORY

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